

Date: Thursday, 9/14/2006 7:28:19 AM  
User: Kim Johnston

# Process Sheet

|                                  |  |                         |                            |
|----------------------------------|--|-------------------------|----------------------------|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services                                      | <b>Drawing Name</b>     | : COVER PLATE ASSEMBLY, LH |
| <b>Job Number</b>                | : 28554  | <b>Part Number</b>      | : D3467047                 |
| <b>Estimate Number</b>           | : 12301  | <b>Drawing Number</b>   | : D3467 REV B              |
| <b>P.O. Number</b>               | : N/A  | <b>Project Number</b>   | : N/A                      |
| <b>This Issue</b>                | : 9/14/2006  | <b>Drawing Revision</b> | : B                        |
| <b>Prsht Rev.</b>                | : NC   | <b>Material</b>         | : N/A                      |
| <b>First Issue</b>               | : N/A  | <b>Due Date</b>         | : 10/6/2006                |
| <b>Previous Run</b>              | : 26949  | <b>Qty:</b>             | 5                          |
| <b>Written By</b>                | : <u>                    </u>  | <b>Um:</b>              | 4 Each                     |
| <b>Checked &amp; Approved By</b> | : <u>                    </u>  |                         |                            |
| <b>Comment</b>                   | : Est Rev: A New Issue 06-04-24 EC<br>Est Rev: B As per Rev B 06-05-24 JLM |                         |                            |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |        |                |
|-----|--------|----------------|
| 1.0 | D34671 | COVER PLATE LH |
|-----|--------|----------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

|     |             |              |        |
|-----|-------------|--------------|--------|
| Qty | Part Number | Description  | Batch  |
| 1   | D3467-1     | Shourd Plate | B26629 |

06/09/18 (5)

|     |        |            |
|-----|--------|------------|
| 2.0 | D34677 | SEAL STRIP |
|-----|--------|------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

|     |             |             |        |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch  |
| 1   | D3467-7     | Doubler     | B26983 |

mf. 06/09/18 (5)

|     |             |                               |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-047

mf. 06/09/18 (5)

|     |        |                                |
|-----|--------|--------------------------------|
| 4.0 | QC5/11 | INSPECT WORK/INSPECT SPOT WELD |
|-----|--------|--------------------------------|



**Comment:** INSPECT WORK/INSPECT SPOT WELD

SB 06/09/18 (5)

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:28:19 AM  
User: \* Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE ASSEMBLY, LH

Job Number: 28554

Part Number: D3467047

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST351

DB06/09/15

5

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DB06/09/15

5

Job Completion



W 06/09/19

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

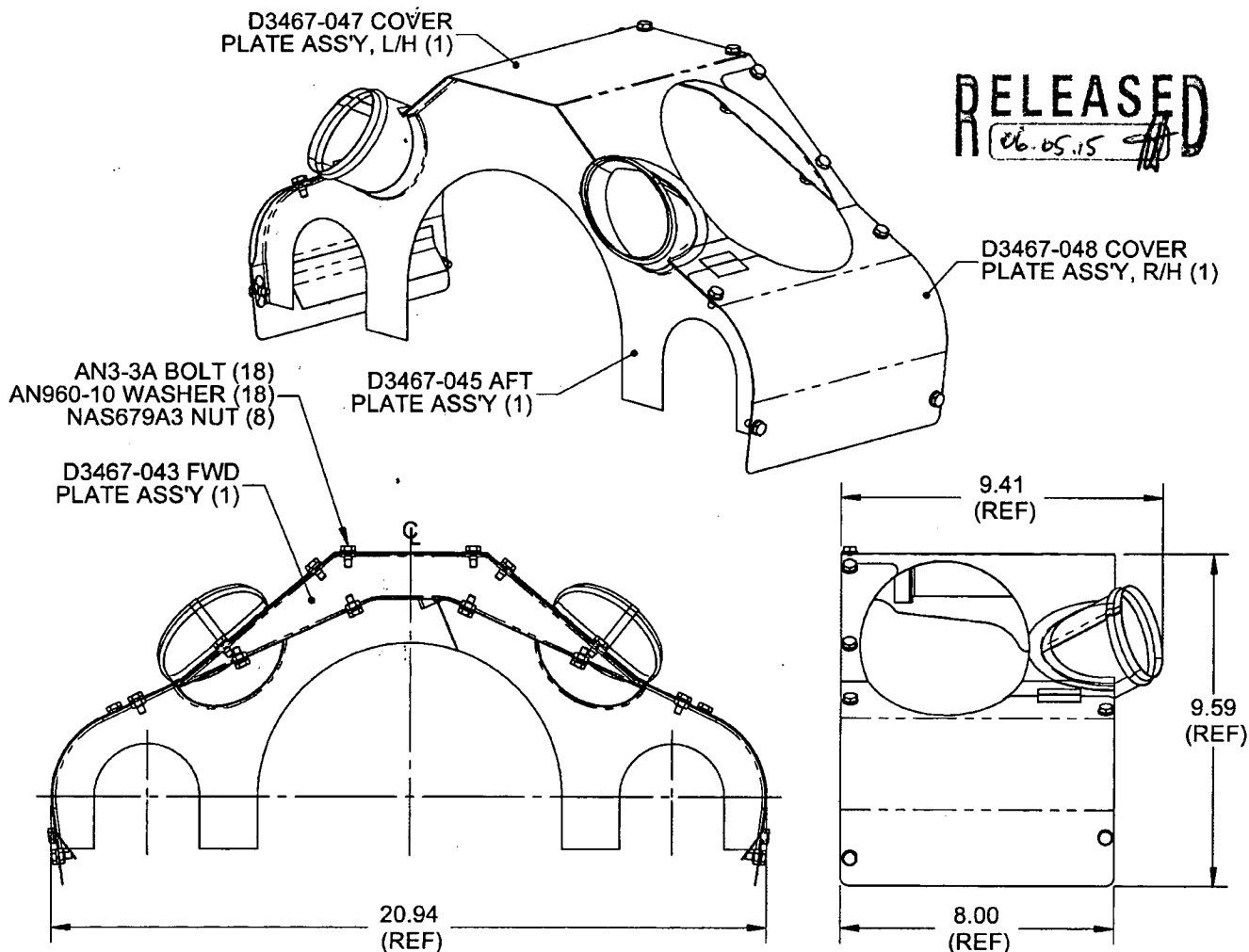
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                  |               |  |                         |
|------------------|---------------|--|-------------------------|
| DESIGN<br>B      | DRAWN BY<br>B | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA      |                         |
| CHECKED<br>H     | APPROVED<br>H | DRAWING NO.<br>D3467                                   | REV. B<br>SHEET 1 OF 15 |
| DATE<br>06.05.15 |               | TITLE<br>SHROUD ASSEMBLY                               | SCALE<br>1:5            |
| A                | 05.12.07      | NEW ISSUE  |                         |
| B                | 06.05.15      | Ø0.250 & Ø0.203 WERE Ø0.194 ;<br>UPDATED D3467-9F/-15F |                         |



### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

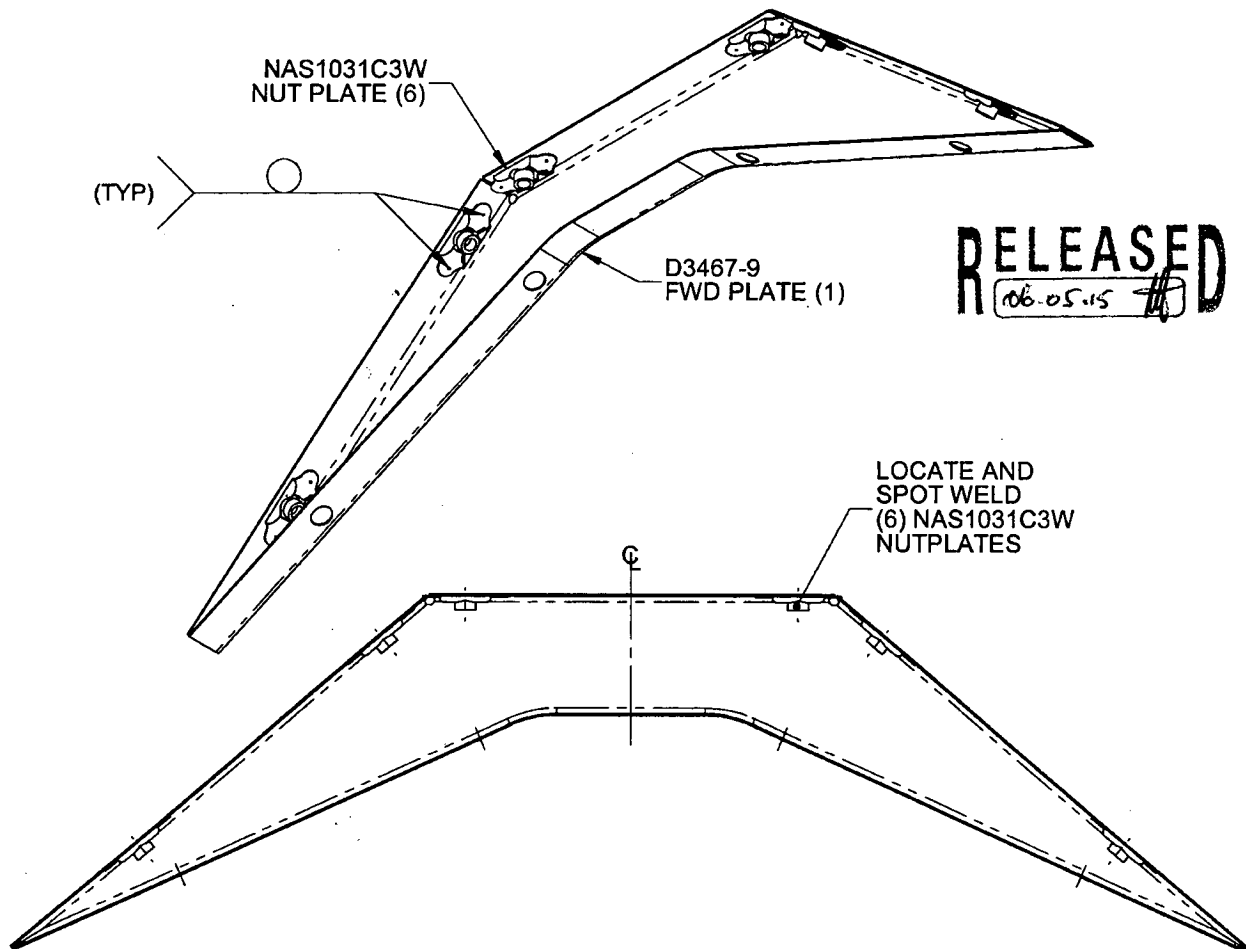
| QTY<br>-041 | P/N       | DESCRIPTION               | RETURN TO<br>ENGINEERING |
|-------------|-----------|---------------------------|--------------------------|
| X           | D3467-041 | SHROUD ASSEMBLY           | UNCONTROLLED COPY        |
| 1           | D3467-043 | FWD PLATE ASSEMBLY        | SUBJECT TO AMENDMENT     |
| 1           | D3467-045 | AFT PLATE ASSEMBLY        | WITHOUT NOTICE           |
| 1           | D3467-047 | COVER PLATE ASSEMBLY, L/H | WORK ORDER               |
| 1           | D3467-048 | COVER PLATE ASSEMBLY, R/H |                          |
| 18          | AN3-3A    | BOLT                      |                          |
| 18          | AN960-10  | WASHER                    |                          |
| 8           | NAS679A3  | NUT                       |                          |

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| DATE<br><b>06.05.15</b> |               | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |



| QTY<br>-043 | P/N        | DESCRIPTION        |
|-------------|------------|--------------------|
| X           | D3467-043  | FWD PLATE ASSEMBLY |
| 1           | D3467-9    | FWD PLATE          |
| 6           | NAS1031C3W | NUT PLATE          |

**D3467-043 FWD PLATE ASSEMBLY****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

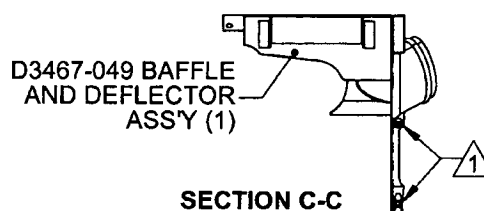
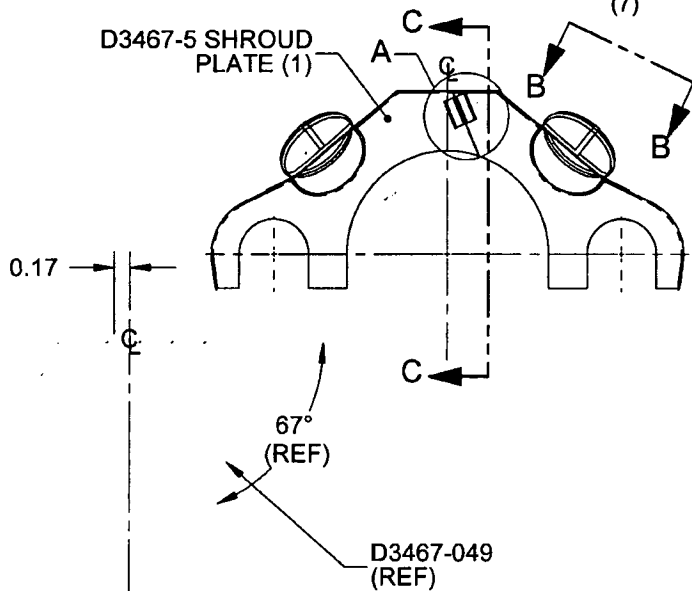
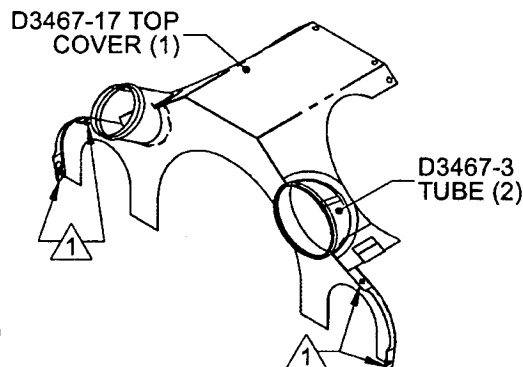
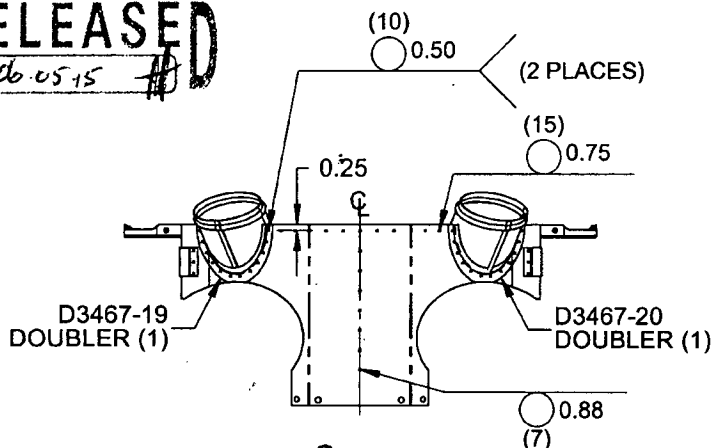
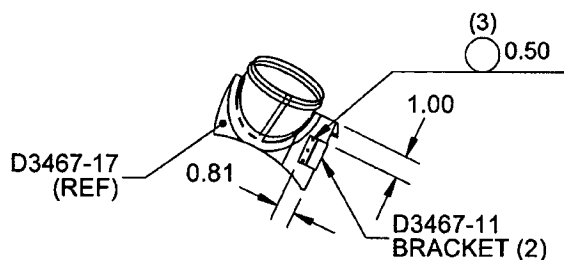
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| DATE<br><b>06.05.15</b> |                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:8            |

**RELEASED**  
06.05.15**SECTION C-C****VIEW B-B: WELDING D3467-11**  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)**DETAIL A**  
SCALE 1:2**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

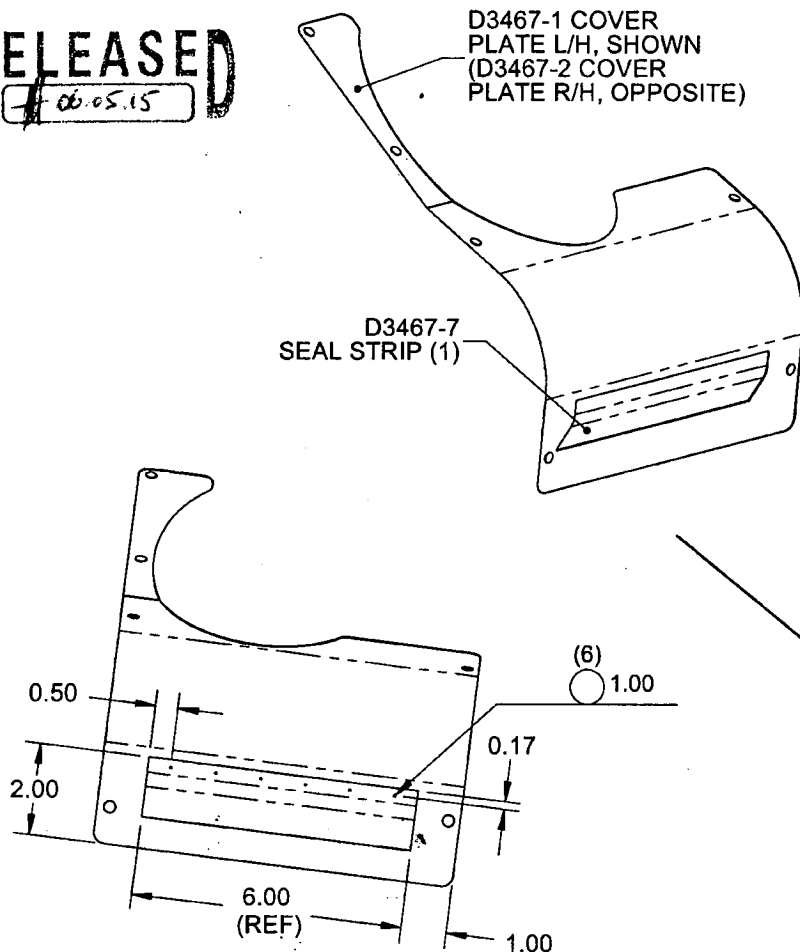
| QTY<br>-045 | P/N        | DESCRIPTION                   |
|-------------|------------|-------------------------------|
| X           | D3467-045  | AFT PLATE ASSEMBLY            |
| 1           | D3467-049  | BAFFLE AND DEFLECTOR ASSEMBLY |
| 2           | D3467-3    | TUBE                          |
| 1           | D3467-5    | SHROUD PLATE                  |
| 2           | D3467-11   | BRACKET                       |
| 1           | D3467-17   | TOP COVER                     |
| 1           | D3467-19   | DOUBLER                       |
| 1           | D3467-20   | DOUBLER                       |
| 4           | NAS1031C3W | NUT PLATE                     |

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| DATE<br><b>06.05.15</b> |               | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:4            |

**RELEASED**  
06.05.15

**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

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**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO  
0.010

| QTY<br>-047 | QTY<br>-048 | P/N       | DESCRIPTION               |
|-------------|-------------|-----------|---------------------------|
| X           |             | D3467-047 | COVER PLATE ASSEMBLY, L/H |
|             | X           | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 1           |             | D3467-1   | COVER PLATE, L/H          |
|             | 1           | D3467-2   | COVER PLATE, R/H          |
| 1           | 1           | D3467-7   | SEAL STRIP                |

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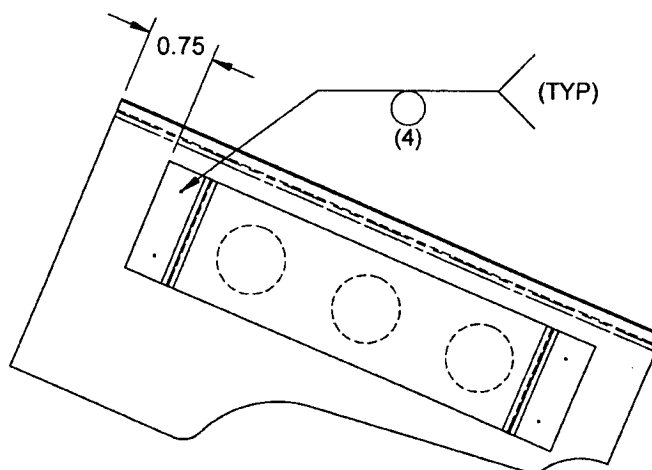
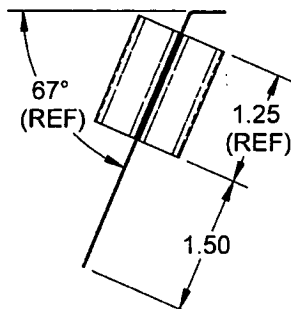
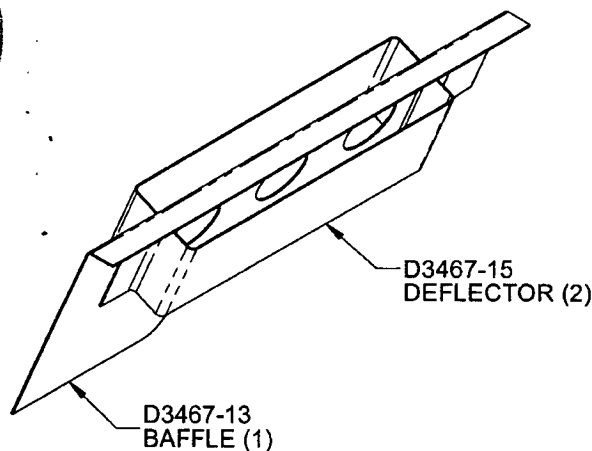
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| DATE<br><b>06.05.15</b> |               | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |

RELEASED  
06.05.15



**D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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NO. 28554

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

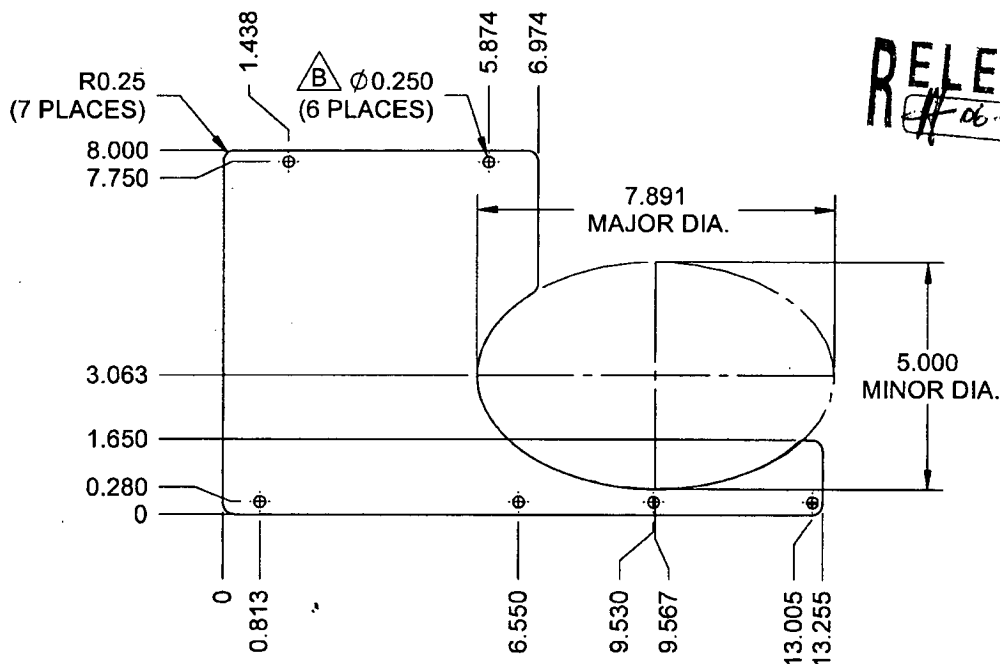
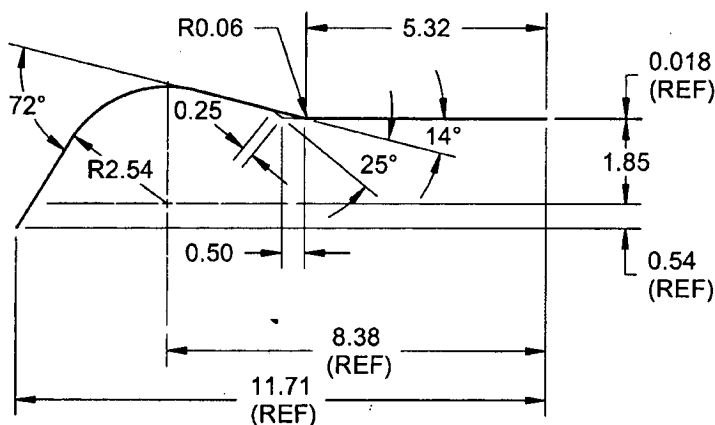
| QTY<br>-049 | P/N       | DESCRIPTION                 |
|-------------|-----------|-----------------------------|
|             | D3467-049 | BAFFLE & DEFLECTOR ASSEMBLY |
| 1           | D3467-13  | BAFFLE                      |
| 2           | D3467-15  | DEFLECTOR                   |

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| CHECKED<br>#13   | APPROVED<br>#13 | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 6 OF 15 |
| DATE<br>06.05.15 |                 | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE  
D3467-2 R/H COVER PLATE (OPPOSITE)****D3467-1 L/H COVER PLATE ISOMETRIC VIEW  
D3467-2 R/H COVER PLATE (OPPOSITE)**

SCALE 1:8 HOP COPY

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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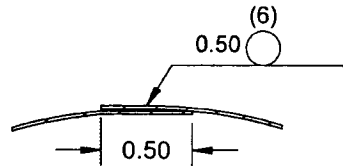
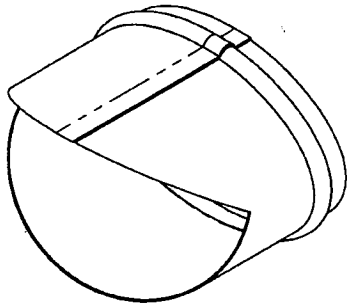
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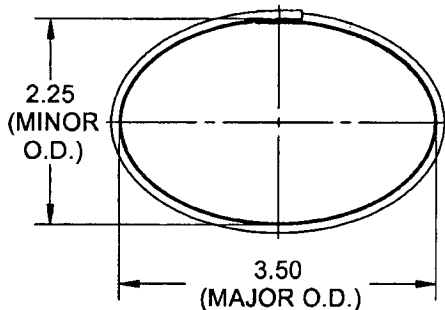


|                               |                                |  |                         |
|-------------------------------|--------------------------------|--|-------------------------|
| DESIGN<br><i>JB</i>           | DRAWN BY<br><i>JB</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 7 OF 15 |
| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |

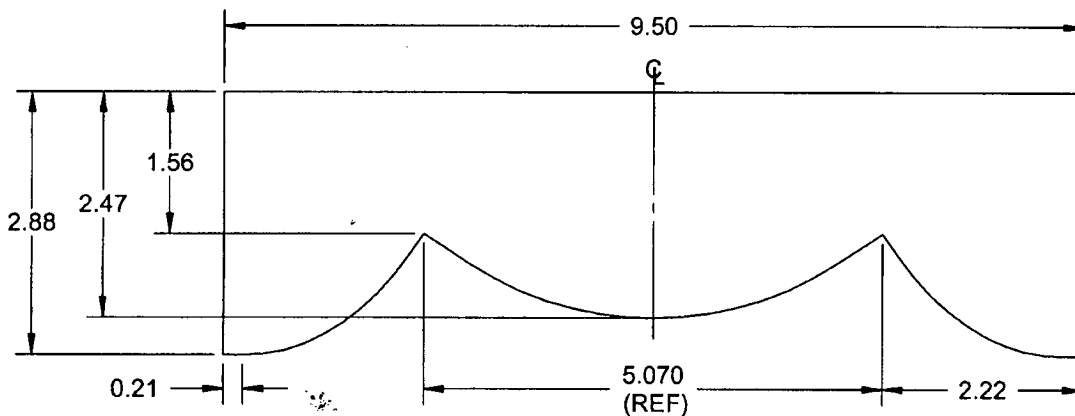
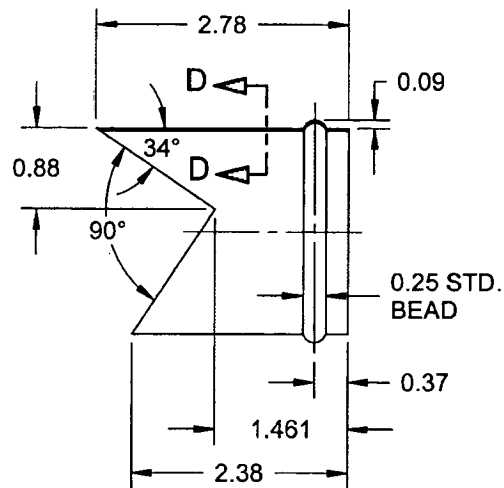
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*06.05.15*



**SECTION D-D**  
SCALE 1:1



**D3467-3 TUBE DETAIL**



**D3467-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

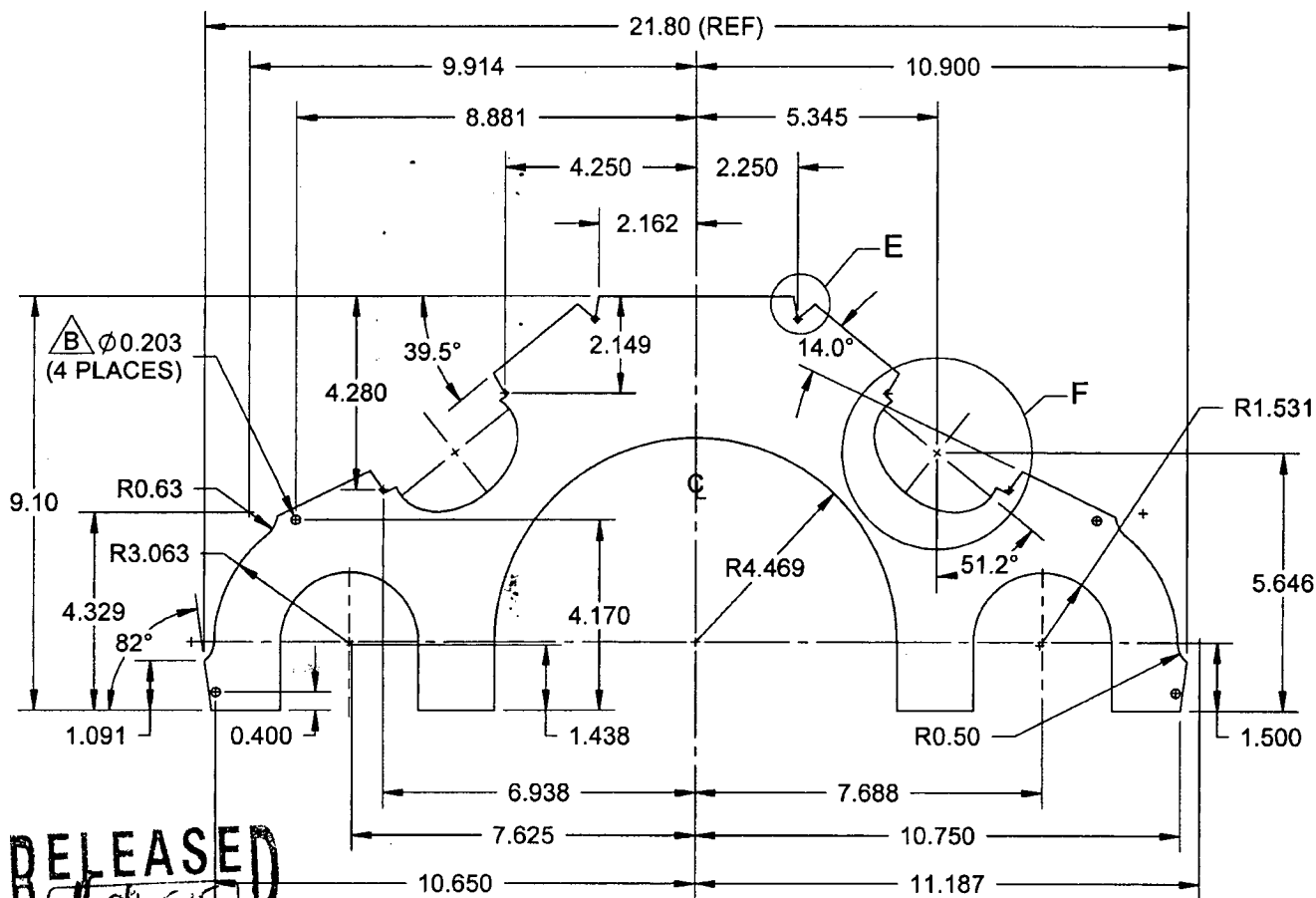
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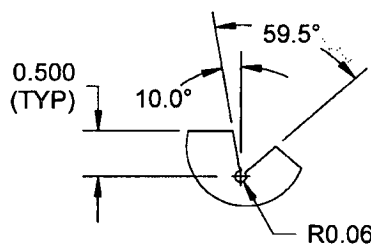
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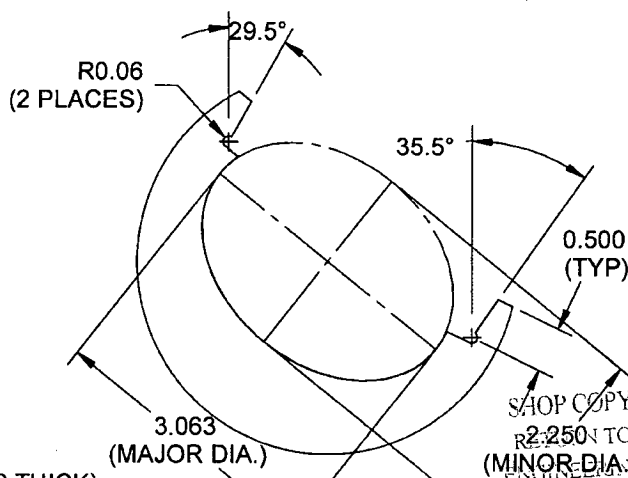
|                               |                                 |  |
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| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i>  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i>  | DRAWING NO.<br><b>D3467</b>                              |
| DATE<br><b>06.05.15</b>       | TITLE<br><b>SHROUD ASSEMBLY</b> | REV. B<br>SHEET 8 OF 15<br>SCALE<br>1:8                  |



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# 06-05-15



**DETAIL E**  
SCALE 1:2



**DETAIL F**  
SCALE 1:2

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### D3467-5F AFT PLATE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

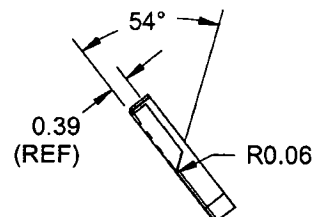
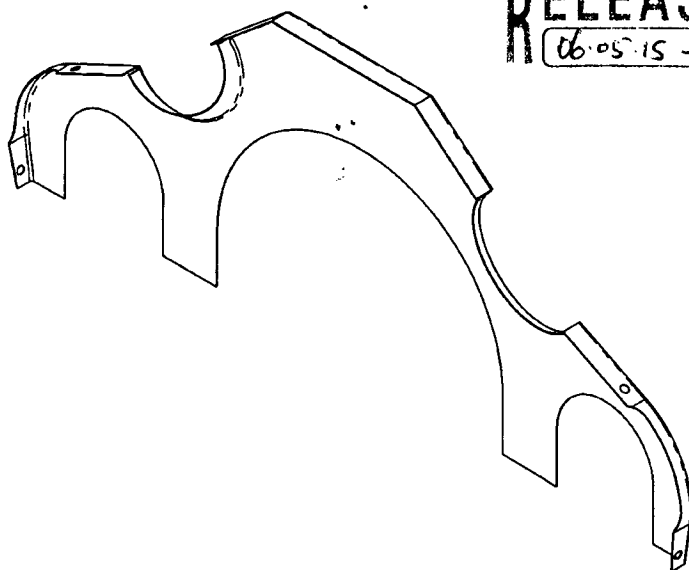
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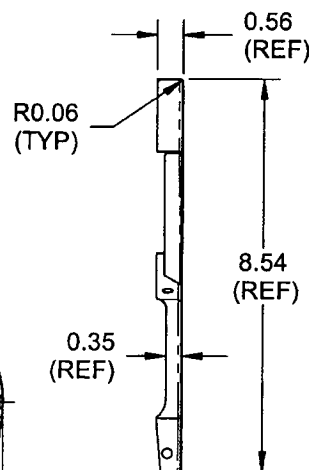
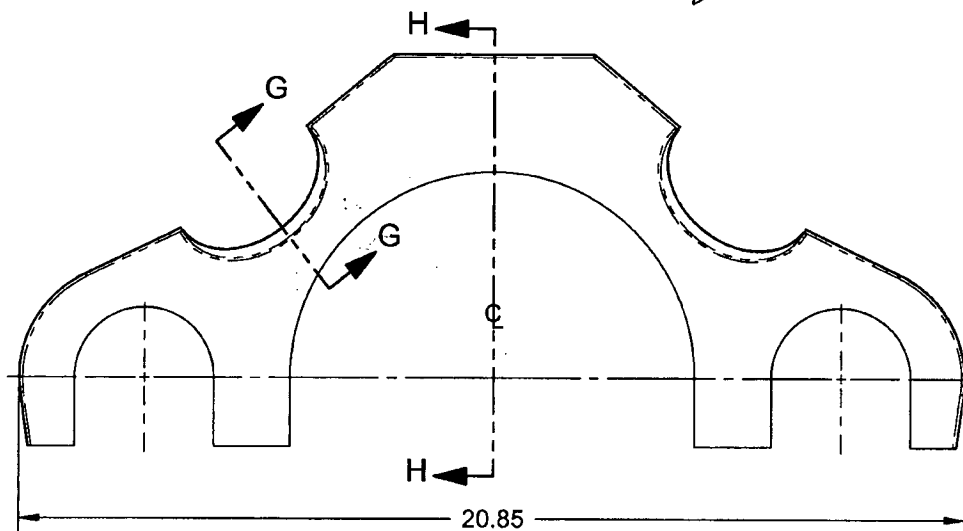
**DART**

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|------------------|---------------|---|-------------------------|
| DESIGN<br>B      | DRAWN BY<br>B | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br>H     | APPROVED<br>H | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 9 OF 15 |
| DATE<br>06.05.15 |               | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |

RELEASED  
06.05.15



**SECTION G-G**



**SECTION H-H**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

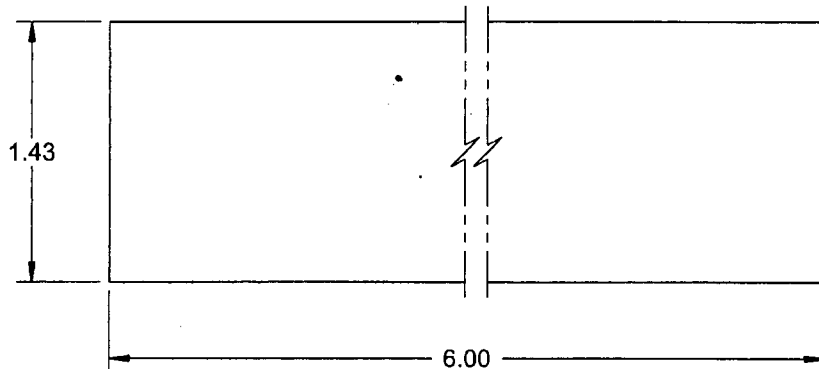
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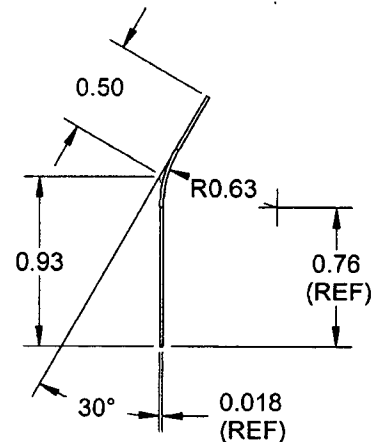
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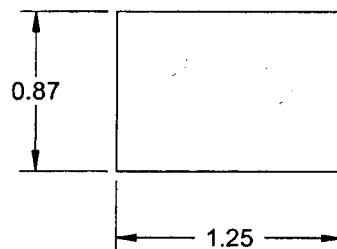
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|-------------------------------|--------------------------------|--|--------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                          |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 10 OF 15 |
| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:1             |

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*[Stamp]*

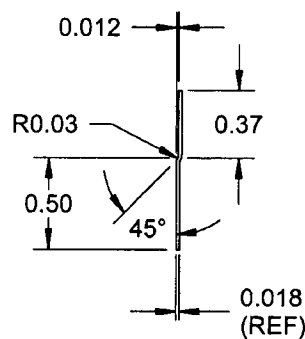
**D3467-7F SEAL STRIP**  
**FLAT PATTERN**



**D3467-7 SEAL STRIP**  
**BENDING DETAIL**



**D3467-11F BRACKET**  
**FLAT PATTERN**



**D3467-11 BRACKET**  
**JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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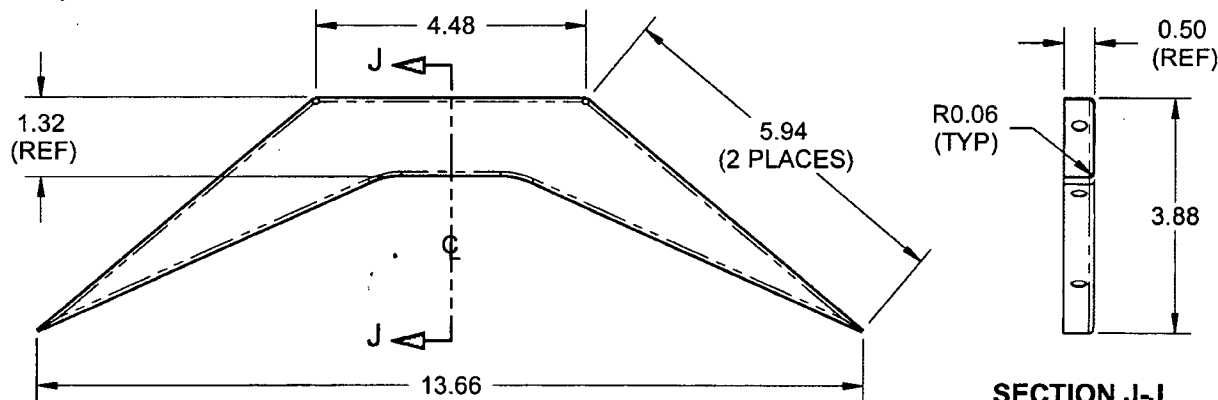
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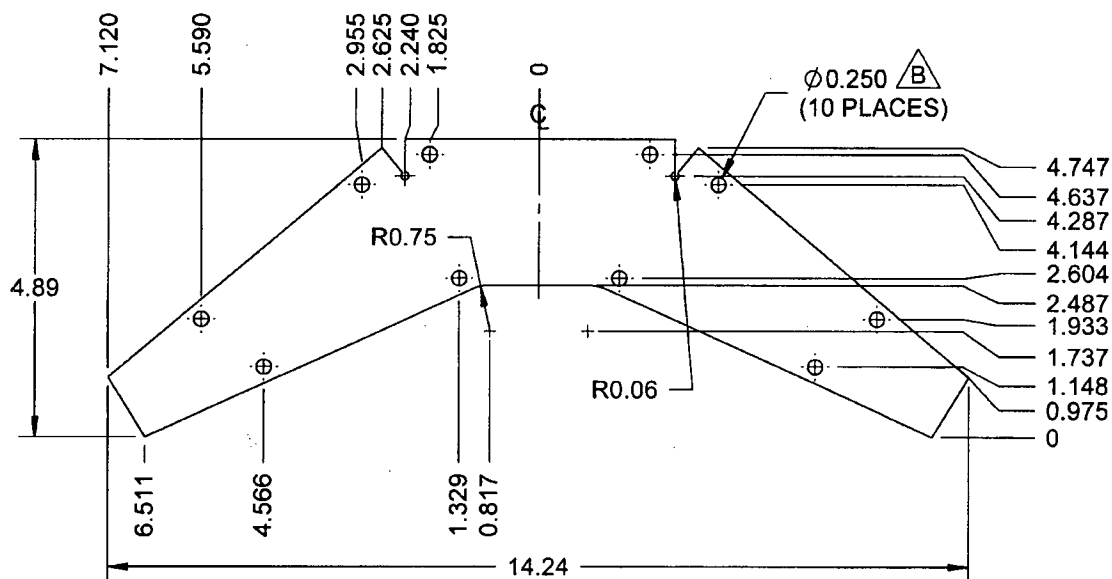


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| DESIGN<br><i>B</i>      | DRAWN BY<br><i>B</i>            | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                          |
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| DATE<br><b>06.05.15</b> | TITLE<br><b>SHROUD ASSEMBLY</b> |  | SCALE<br>1:3             |

**RELEASED**  
*06.05.15*



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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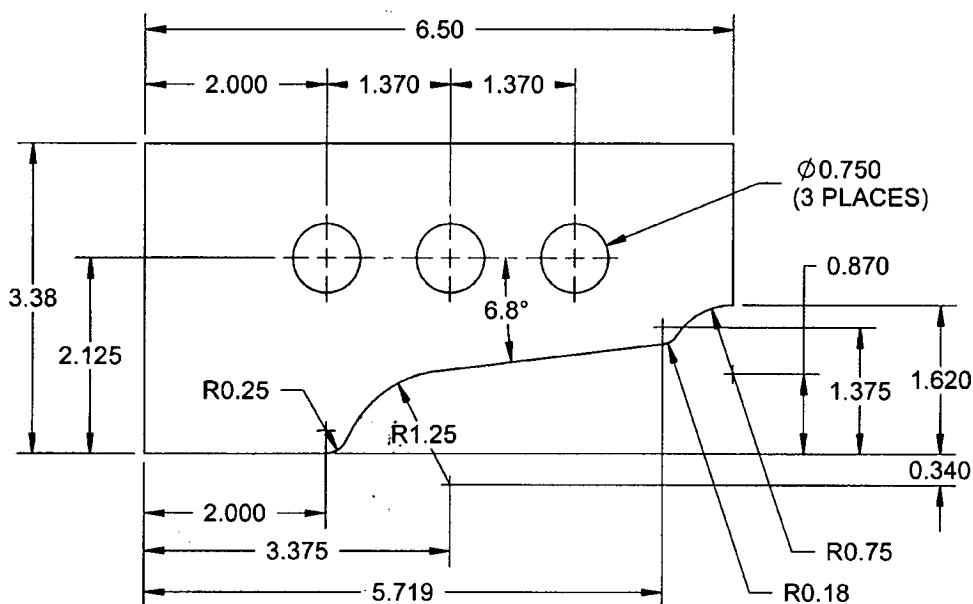
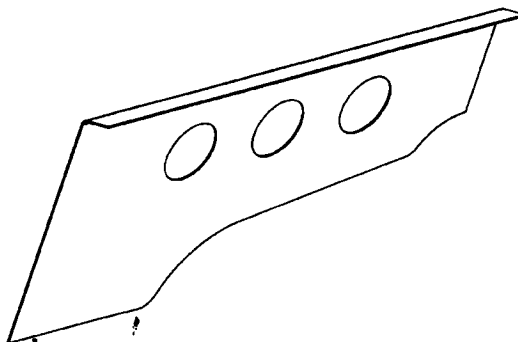
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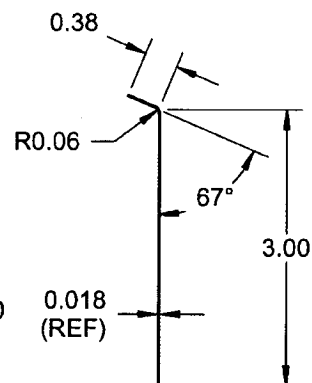


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| CHECKED<br>#     | APPROVED<br>#   | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 12 OF 15 |
| DATE<br>06.05.15 |                 | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2             |

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# 06-05-15



**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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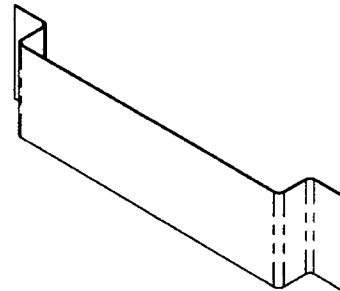
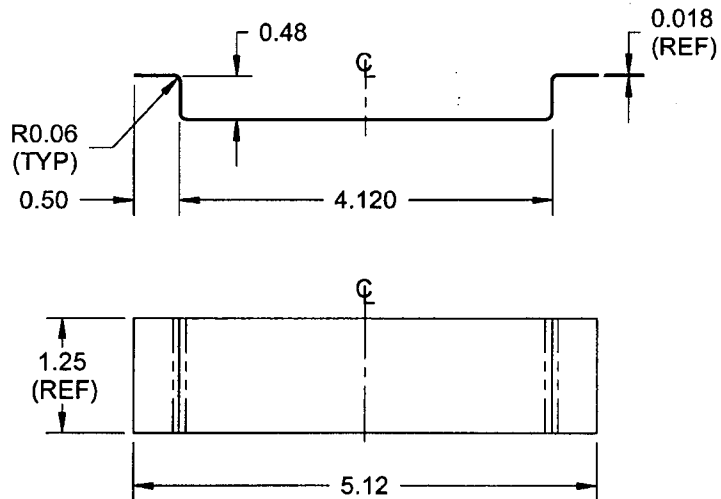
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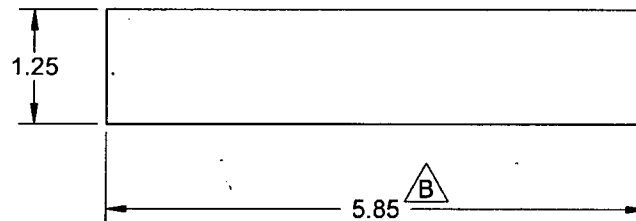


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| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2             |

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### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC, M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

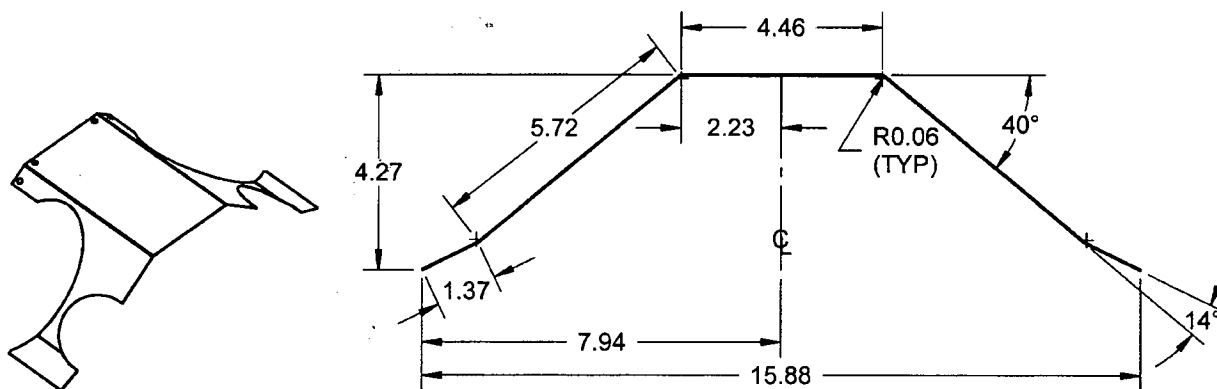
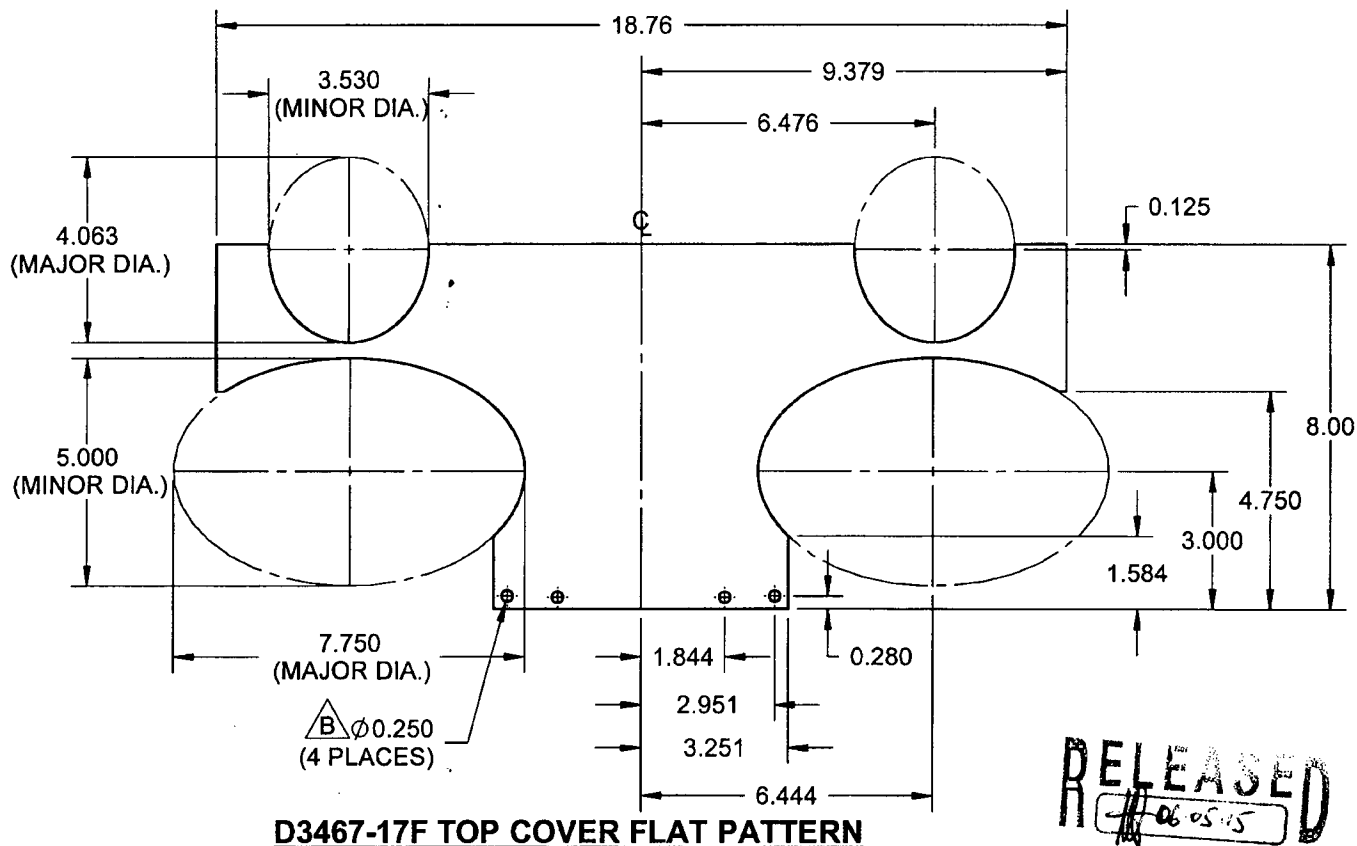
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| DATE<br><b>06.05.15</b>       | TITLE<br><b>SHROUD ASSEMBLY</b> |  | SCALE<br>1:4             |



### D3467-17 TOP COVER BENDING DETAIL

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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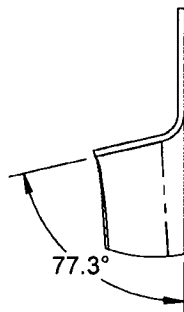
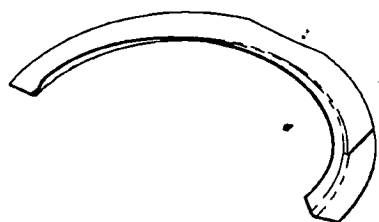
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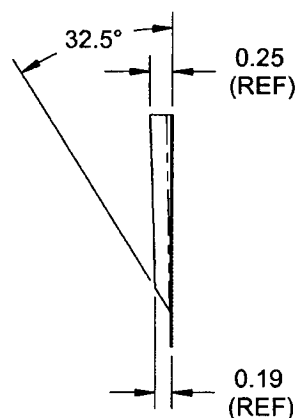
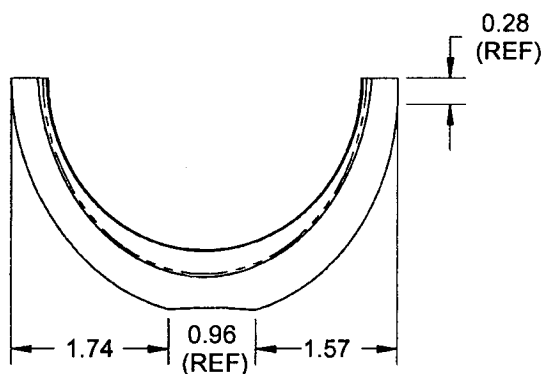
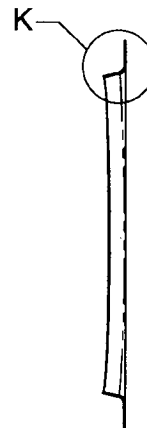


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| DESIGN<br><i>13</i>     | DRAWN BY<br><i>13</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                          |
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| DATE<br><b>06.05.15</b> |                       | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2             |

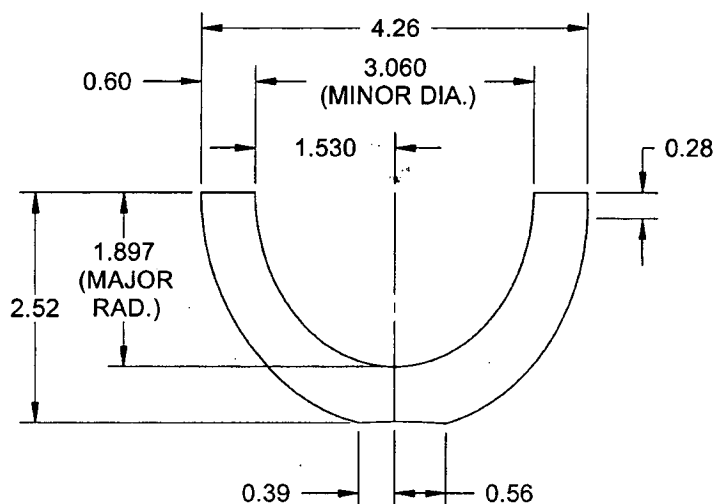
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*06.05.15*



**DETAIL K**  
SCALE 1:2



**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**



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**D3467-19F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 6

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Sylvie Boucher  
Joint Welding Procedure Spot weld  
Part number and Job number A3467047 / B28554

TEST WELDS REQUIRED

BASE METAL S.S. WELDING PROCESS Spot Weld  
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐  
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

|              | Position                    | Vertical                    | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/>   | 4G <input type="checkbox"/> |
| Tube Groove  | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/>   | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/>   | 4F <input type="checkbox"/> |
| Tube Fillet  | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/>   | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/09/19 Qualifier David David